

Date: Tuesday, 7/1/2008 10:47:13 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : RIGHT ARM WELDMENT
 Job Number : 40160
 Estimate Number : 12281
 P.O. Number :
 This Issue : 7/1/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : LARGE FAB ASSY
 Previous Run : 36214
 Written By :
 Checked & Approved By : 08.07.01
 Comment :
 est rev : A 06.02.09 new issue EC
 est B 07.05.14 rev B dwg EC
 Est Rev: C 07-12-10 rev C dwg DD verified by: EC

Part Number : D3354042 FR
 Drawing Number : D3354 REV C
 Project Number : N/A
 Drawing Revision : C
 Material :
 Due Date : 7/30/2008

Qty:

Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 D33549 Handle Socket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty part number description batch
 1 D3354-9 Handle socket

batch

~~B41362~~ B42498

pl 09.04.30

2.0 D33541 Inner Shaft



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty part number description batch
 1 D3354-1 Inner shaft

batch

~~B36231~~ B44362

pl 09.04.30

3.0 D33547 Left Arm Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty part number description batch
 1 D3354-7 Left arm plate

batch

~~B31303~~ → 1✓

~~B36233~~ → 1✓

pl 09.04.30

4.0 D33543 Wheel Shaft



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty part number description batch
 1 D3354-3 Shaft

batch

~~B36232~~ → 1

~~B42763~~ → 3

pl 09.04.30

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Tuesday, 7/1/2008 10:47:13 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RIGHT ARM WELDMENT

Job Number: 40160

Part Number: D3354042

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

TP134

Inventory



Comment: Qty 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

TP-134 TENSION PIN

Batch: M16362 ✓

LP 09.04.30

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- Weld assembly as per dwg D3354

2-Grind welds flush as per dwg D3354

LP 09.05.01 (2)

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09.05.04 (2)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 02/05/04 (x2)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1-Mask areas indicated on dwg D3354

2-Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

START TIME:

8:45

OVEN TEMPERATURE:

320°

FINISH TIME:

9:15

FL 09/05/06

(2)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR BR 09-05-6 (2)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Carl L.

8/5/05/11 (x2)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Date: Tuesday, 7/1/2008 10:47:13 AM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RIGHT ARM WELDMENT

Job Number: 40160

Part Number: D3354042

Job Number:



Seq. #:

Machine Or Operation:

Description :

120

QC21

FINAL INSPECTION/W/O RELEASE



09/05/11 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-05-11

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

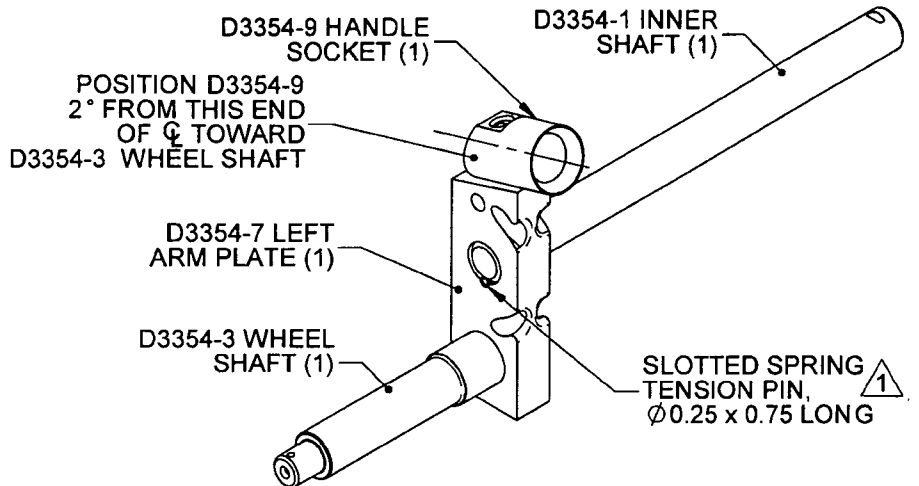
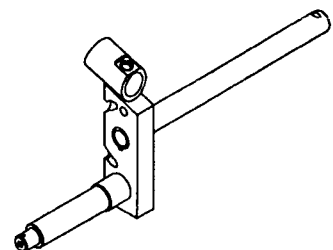
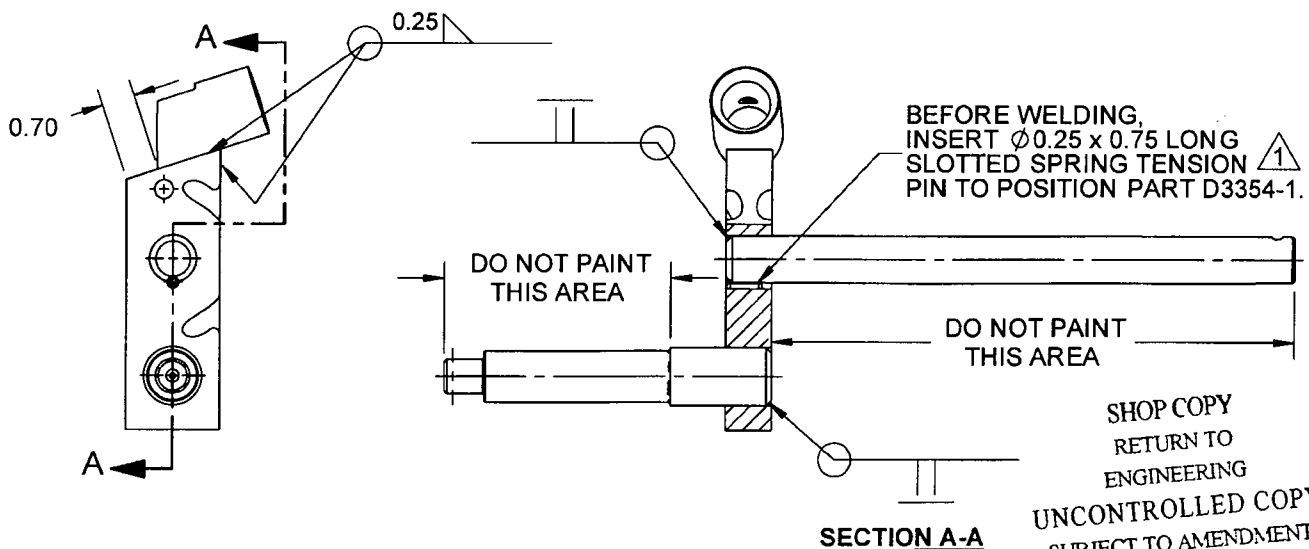
QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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| DATE 07.12.06 | | TITLE D3354 | SCALE 1:4 |
| REV | DATE | DESCRIPTION | |
| A | 04.12.13 | NEW ISSUE | |
| B | 07.02.02 | REVISED DIMENSIONS | |
| C | 07.12.06 | CHANGE TOLERANCE ON D3354-7 LEFT ARM PLATE HOLE FOR D3354-3 WHEEL SHAFT | |

RELEASED
07.12.07**D3354-041 LEFT ARM WELDMENT****D3354-042 MIRROR ARM WELDMENT**

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WITHOUT NOTICE
WORK ORDER
NO. *40160*

NOTES:

- 1) POSSIBLE SUPPLIER: SPAENAU, P/N TP-134
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

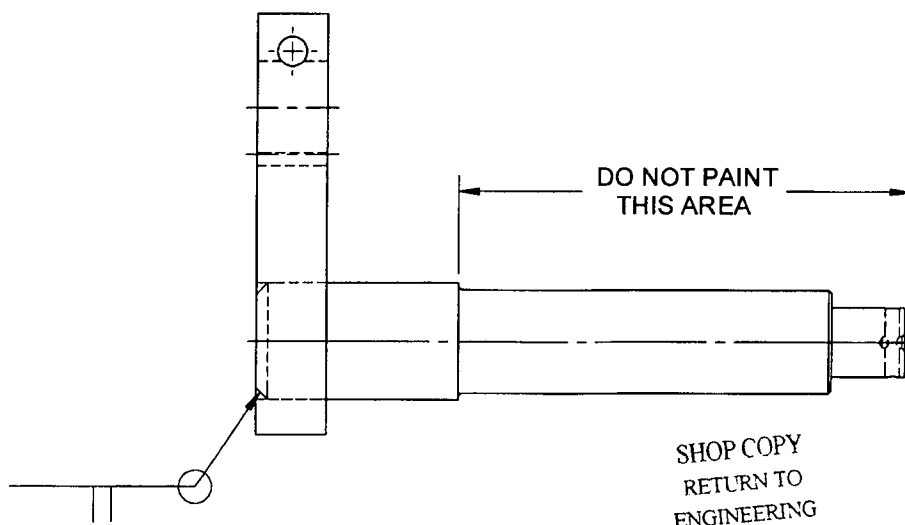
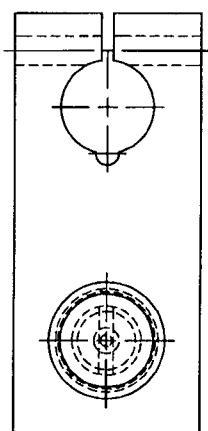
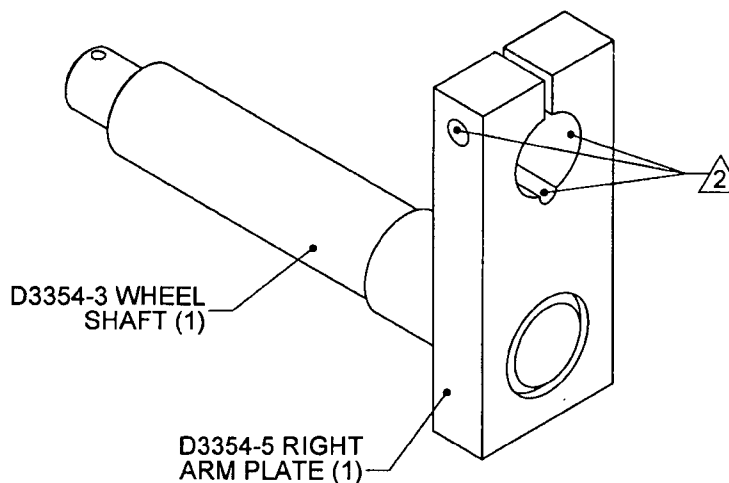
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| DATE 07.12.06 | | TITLE LEFT ARM WELDMENT | |
| | | SCALE 1:2 | |

RELEASED
07/12/07 *WJ*



D3354-043 RIGHT ARM WELDMENT

NOTES:

- 1) WELD PER DART QSI 004
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

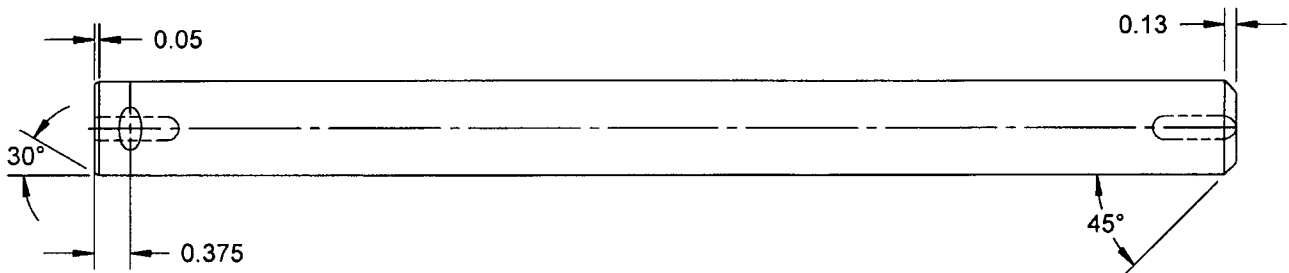
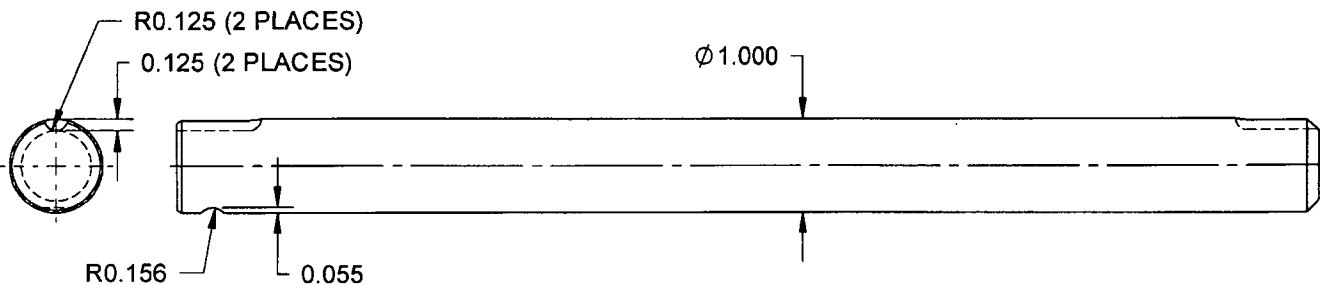
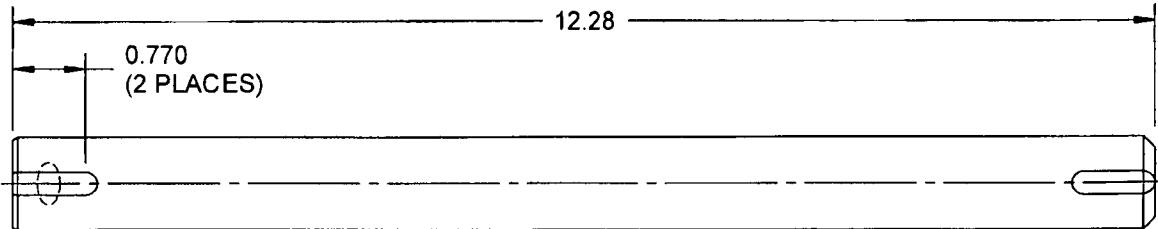
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| DATE 07.12.06 | | TITLE LEFT ARM WELDMENT | SCALE 1:2 |

RELEASED
07/12/07 [Signature]**D3354-1 INNER SHAFT**

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NOTES:

- 1) MATERIAL: AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-91 OR UNS#-G41400 ROUND BAR, $\phi 1.250$ (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

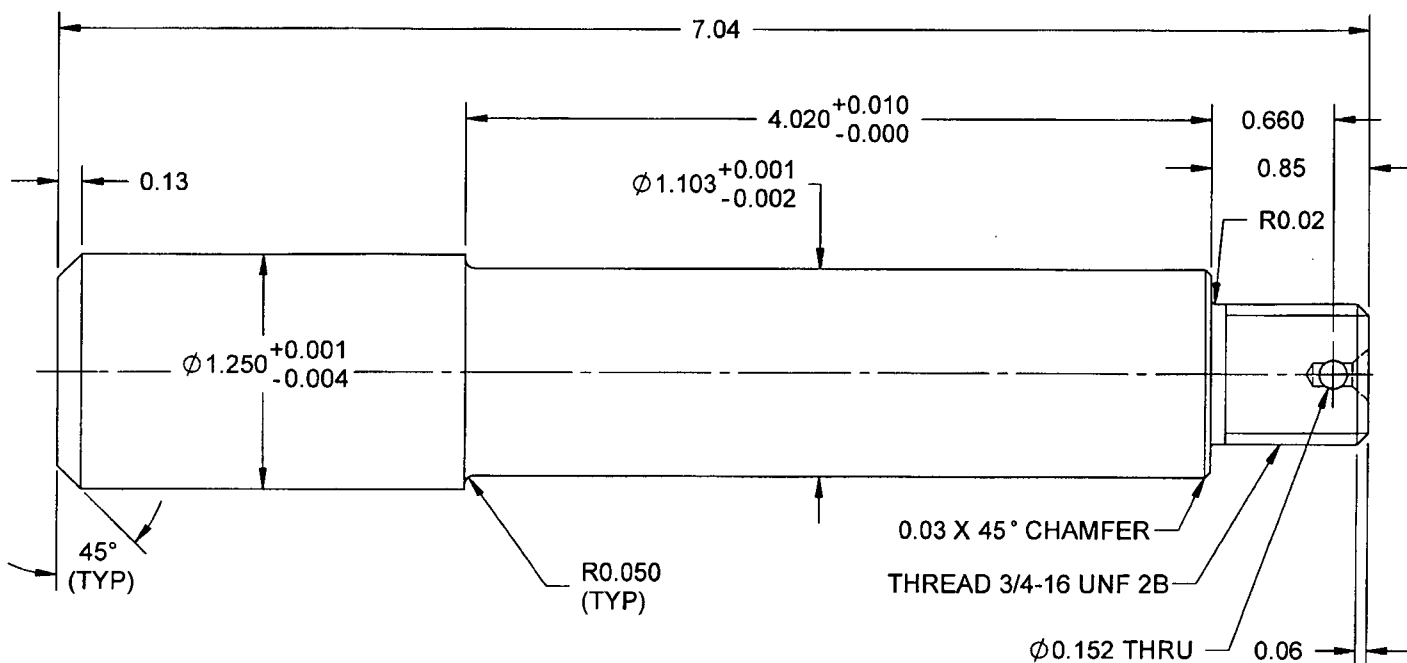
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| DATE 07.12.06 | | TITLE LEFT ARM WELDMENT | SCALE 1:1 |

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07.12.07 *[Signature]*



D3354-3 WHEEL SHAFT

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NOTES:

- 1) MATERIAL: AISI-4130/ AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-91 OR UNS#-G41400 ROUND BAR, $\phi 1.250$ (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

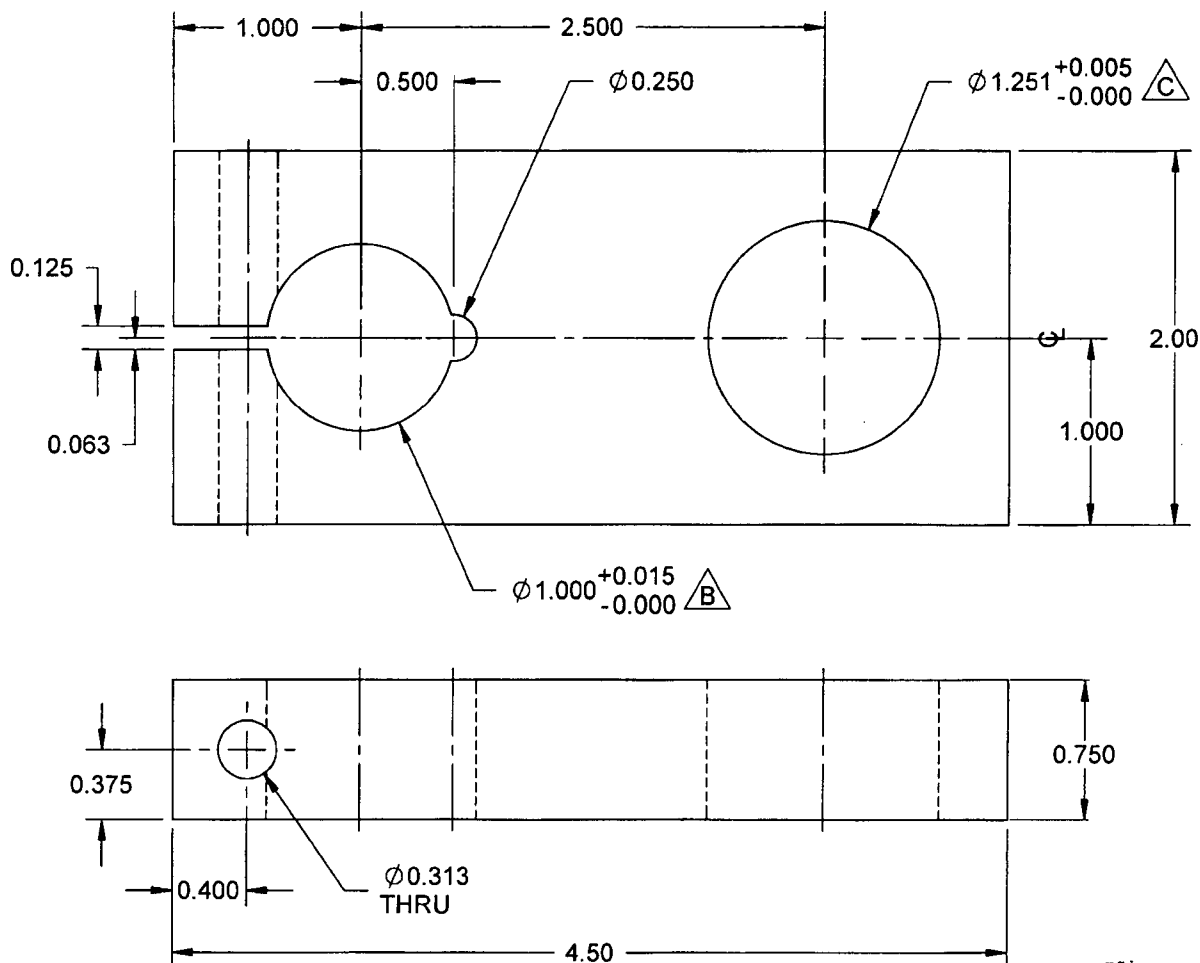
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| DATE 07.12.06 | | TITLE LEFT ARM WELDMENT | SCALE 1:1 |

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07/12/07 *[Signature]*



D3354-5 RIGHT ARM PLATE





NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 0.75 THICK MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

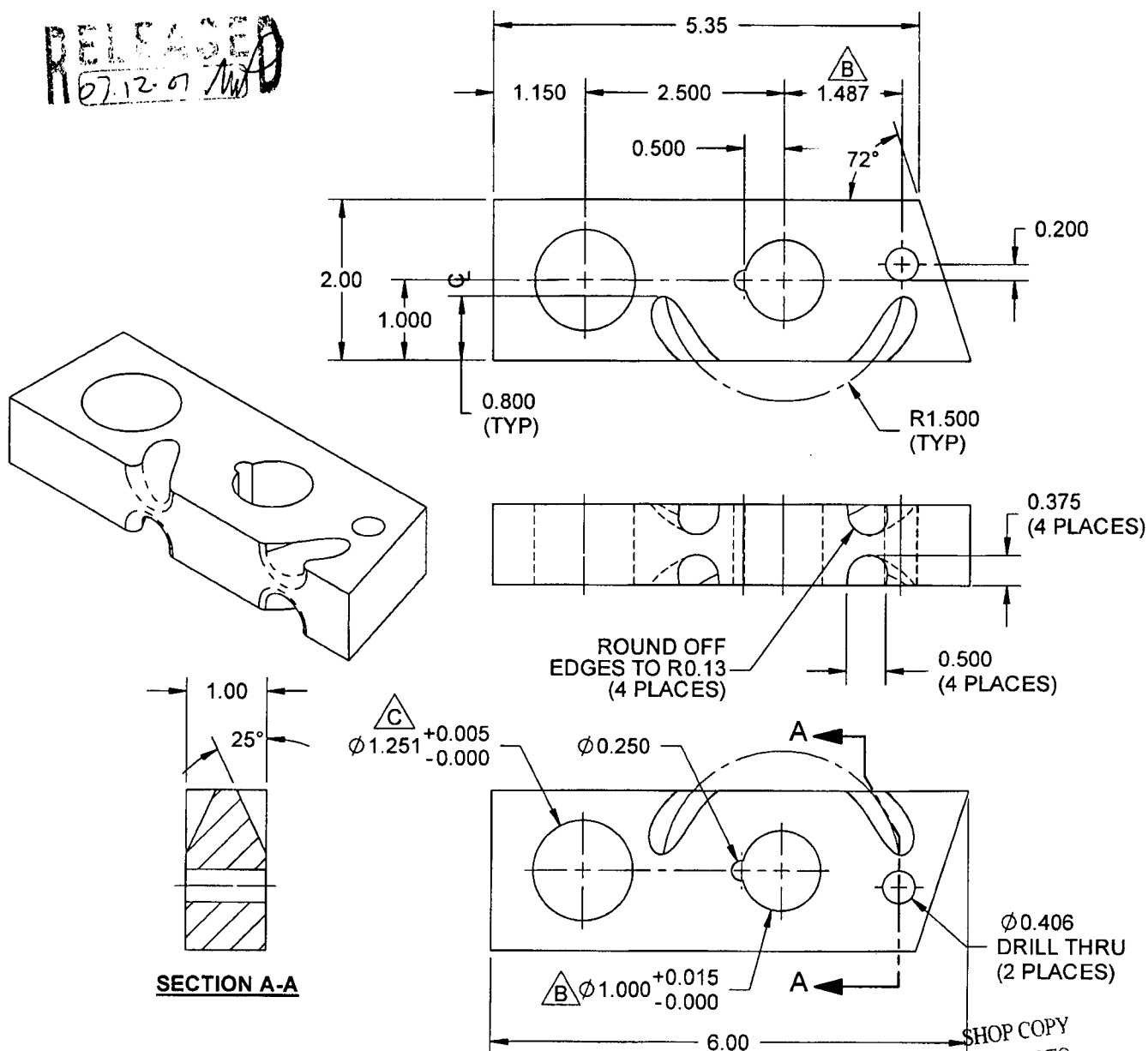
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| DATE 07.12.06 | | TITLE LEFT ARM WELDMENT | SCALE 1:2 |

RELEASED
07.12.07



D3354-7 LEFT ARM PLATE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR
CSA G40.21, 38W/44W/50W/60W/70W, 1.00 THICK MILD
STEEL BAR (REF. DART SPEC. M1010-B)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.010 TO 0.020

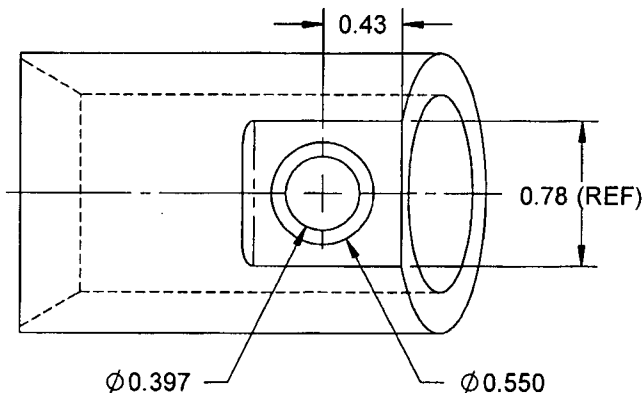
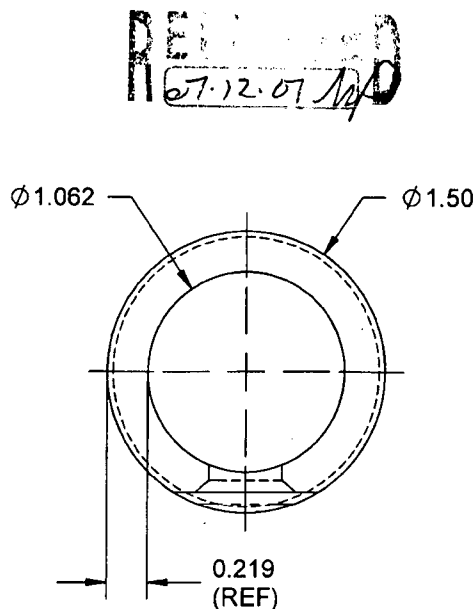
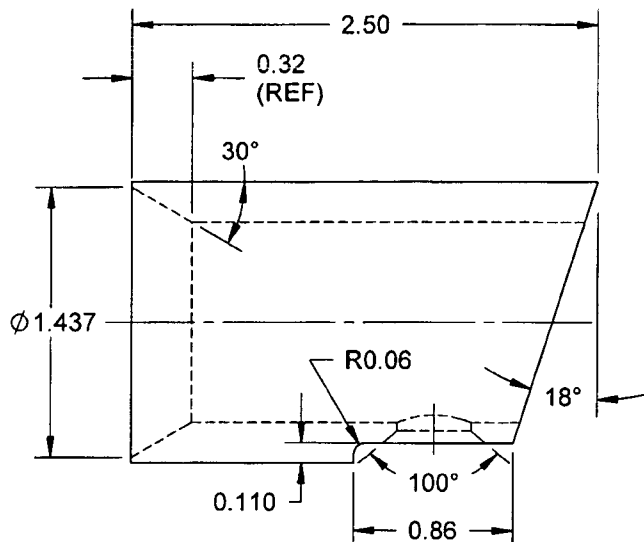
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| CHECKED <i>LS</i> | APPROVED <i>MP</i> | DRAWING NO. D3354 | REV. C SHEET 7 OF 7 |
| DATE 07.12.06 | | TITLE LEFT ARM WELDMENT | SCALE 1:1 |



D3354-9 HANDLE SOCKET

NOTES:

- 1) MATERIAL: AISI 1010-1025 SEAMLESS ROUND TUBING PER MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077, (REF. DART SPEC. M1020TR1.250W.219)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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